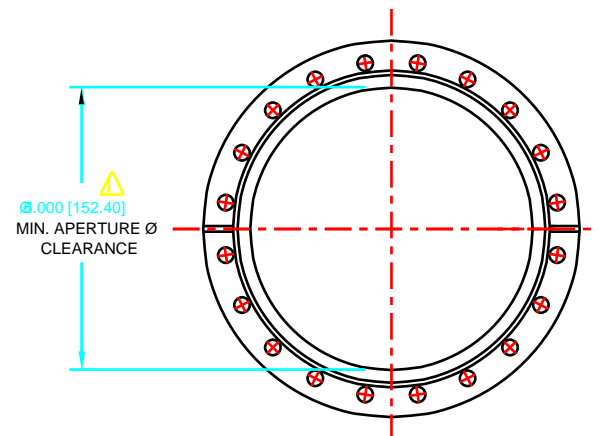
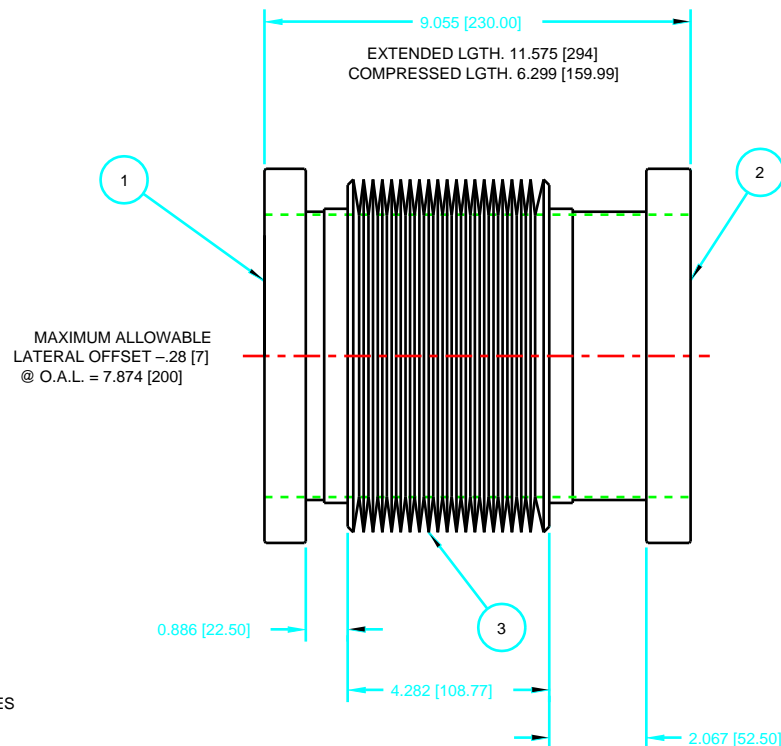


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NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE		1
1	MDC'S CAT. #110031	8" CF. NONROTATABLE FLANGE		1

ITEM	BYG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES.		LOG NUMBER		THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		V2950000-01		ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGLES				

1	0.03 [.7620]	0.25	DATE	2/18/93	CHEF DESIGN ENGINEER	DATE	7/6/99
2	0.01 [0.254]		CHECKED BY	7/6/99	OP LEADER	DATE	7/6/99
3	0.005 [0.127]		DESIGNER	7/6/99	T.M. KUZAY	DATE	7/6/99

SURFACE ROUGHNESS 125		DESIGNER		PROJECT WORK	
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ.		SHU/MUSCIA			
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. 944.		RESPONSIBLE ENGINEER		APPROVED/RELEASED	

APPROVED/RELEASED		DATE		TITLE	
D. SHU		7/6/99		ADVANCED PHOTON SOURCE	
				V2-95 WELDED BELLOWS ASSY.	

MATERIAL		SCALE		SHEET	
SEE PARTS LIST		HALF		104	
		C		DRAWING NUMBER	

DO NOT SCALE DRAWING		V2-950000-01	
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